

AMENDMENTS TO THE CLAIMS

The following listing of claims will replace all prior versions and listings of claims in the application.

LISTING OF CLAIMS

1 – 11 cancelled.

12. (currently amended) An ultra high molecular weight polyethylene block having a molecular weight of not less than ~~about~~5 million, having been crosslinked by irradiation at a level of at least ~~about~~1 MR, and having then been heated, subjected to pressure after heating, and then cooled.

13. (currently amended) An ultra high molecular weight polyethylene block according to Claim 12, wherein said irradiation is gamma irradiation at a level of from ~~about~~1 MR to ~~about~~5 MR.

14. (currently amended) An ultra high molecular weight polyethylene block according to Claim 12, wherein said heating is in a range of from ~~about~~50° C lower than the melting temperature of the crosslinked ultra high molecular weight polyethylene to ~~about~~80° C higher than the melting temperature.

15. (currently amended) An ultra high molecular weight polyethylene block according to Claim 14, wherein said heating is in a range of from ~~about~~50° C lower than the melting temperature of the crosslinked ultra high molecular weight polyethylene to the melting temperature.

16. (currently amended) An ultra high molecular weight polyethylene block according to Claim 15, wherein said heating is in a range from the melting temperature of the crosslinked ultra high molecular weight polyethylene to ~~about~~80° C higher than the melting temperature.

17. (previously presented) An ultra high molecular weight polyethylene block according to Claim 12, wherein said pressure is applied so as to deform the block.

18. (currently amended) An ultra high molecular weight polyethylene block according to Claim 17, wherein ~~deformation~~ the block is deformed in a direction perpendicular to the plane of compression.

19. (previously presented) An ultra high molecular weight polyethylene block according to Claim 17, wherein said block is cooled in a compression-deformed state under pressure.

20. (previously presented) An ultra high molecular weight polyethylene block according to Claim 18, which has an orientation of crystal planes in a direction parallel to the compression plane.

21. (currently amended) An ultra high molecular weight polyethylene block according to Claim 18, wherein said block, after compression, has a thickness of at least ~~about~~ 5 mm in a direction perpendicular to the compression plane.

22. (currently amended) An ultra high molecular weight polyethylene block according to Claim 18, wherein said block, prior to compression, has a thickness of at least ~~about~~ 3 cm.

23. (currently amended) An ultra high molecular weight polyethylene block having a molecular weight of not less than ~~about~~ 5 million, having been crosslinked by irradiation at a level of at least ~~about~~ 1 MR, then ~~and having been~~ heated to a compression-deformable temperature, then subjected to pressure, and thereafter cooled so as to orient the crystal planes of said polyethylene.

24. (previously presented) An ultra high molecular weight polyethylene block according to Claim 23, wherein said pressure is applied so as to compression deform the block in

a direction perpendicular to the compression plane, and wherein said block is cooled and solidified in a compression-deformed state under pressure.

25. (previously presented) An ultra high molecular weight polyethylene block according to Claim 24, wherein said block has an orientation of crystal planes in a direction parallel to the compression plane.

26. (currently amended) An ultra high molecular weight polyethylene block according to Claim 23, wherein said heating is in a range of from ~~about~~ 50° C lower than the melting temperature of the crosslinked ultra high molecular weight polyethylene to ~~about~~ 80° C higher than the melting temperature.

27. (currently amended) An ultra high molecular weight polyethylene block according to Claim 26, wherein said heating is in a range of from ~~about~~ 50° C lower than the melting temperature of the crosslinked ultra high molecular weight polyethylene to the melting temperature.

28. (currently amended) An ultra high molecular weight polyethylene block according to Claim 26, wherein said heating is in a range from the melting temperature of the crosslinked ultra high molecular weight polyethylene to ~~about~~ 80° C higher than the melting temperature.

29. (previously presented) An ultra high molecular weight polyethylene block according to Claim 23, wherein said block has been subjected to isothermal crystallization.

30. (currently amended) An ultra high molecular weight polyethylene block according to Claim 23, wherein said block has been subjected to isothermal treatment at a temperature of from ~~about~~ around 100°C to ~~about~~ 130°C for a period of from ~~about~~ 1 hour to ~~about~~ 20 hours.

31. (currently amended) An ultra high molecular weight polyethylene block having a molecular weight not less than ~~about~~ 5 million, having been crosslinked by irradiation at a level of at least ~~about~~ 1 MR ~~and, then~~ having been heated to a temperature of from ~~about~~ 50° C lower than the melting temperature of the crosslinked ultra high molecular weight polyethylene to the melting temperature, then subjected to pressure thereafter, and cooled.

32. (currently amended) An ultra high molecular weight polyethylene block according to Claim 31, wherein said irradiation is gamma irradiation at a level of from ~~about~~ 1 MR to ~~about~~ 5 MR.

33. (previously presented) An ultra high molecular weight polyethylene block according to Claim 31, wherein said pressure is applied so as to deform the block.

34. (previously presented) An ultra high molecular weight polyethylene block according to Claim 33, wherein said deformation is in a direction perpendicular to the plane of compression.

35. (previously presented) An ultra high molecular weight polyethylene block according to Claim 34, wherein said block is cooled in a compression-deformed state under pressure.

36. (previously presented) An ultra high molecular weight polyethylene block according to Claim 35, which has an orientation of crystal planes in a direction parallel to the compression plane.

37. (currently amended) An ultra high molecular weight polyethylene block according to Claim 34, wherein said block, after compression, has a thickness of at least ~~about~~ 5 mm in a direction perpendicular to the compression plane.

38. (previously presented) An ultra high molecular weight polyethylene block according to Claim 31, wherein said block has been subjected to isothermal crystallization.

39. (currently amended) An ultra high molecular weight polyethylene block according to Claim 31, wherein said block has been subjected to isothermal treatment at a temperature of from ~~about~~around 100°C to ~~about~~ 130°C for a period of from ~~about~~ 1 hour to ~~about~~ 20 hours.

40. (currently amended) A method for producing an ultra high molecular weight polyethylene block, comprising:

- (a) crosslinking an ultra high molecular weight polyethylene block having a molecular weight not less than 5 million by irradiating the block with a high energy radiation at a level of at least ~~about~~ 1 MR;
- (b) heating said crosslinked block up to a compression deformable temperature;
- (c) subjecting said heated block to pressure; and then
- (d) cooling said block.

41. (currently amended) A method for producing an ultra high molecular weight polyethylene block according to Claim 40, wherein said irradiation is gamma irradiation at a level of from ~~about~~ 1 MR to ~~about~~ 5 MR.

42. (currently amended) A method for producing an ultra high molecular weight polyethylene block according to Claim 40, wherein said heating is in a range of from ~~about~~ 50° C lower than the melting temperature of the crosslinked ultra high molecular weight polyethylene to ~~about~~ 80° C higher than the melting temperature.

43. (currently amended) A method for producing an ultra high molecular weight polyethylene block according to Claim 42, wherein said heating is in a range of from ~~about~~ 50° C lower than the melting temperature of the crosslinked ultra high molecular weight polyethylene to the melting temperature.

44. (currently amended) A method for producing an ultra high molecular weight polyethylene block according to Claim 42, wherein said heating is in a range from the melting temperature of the crosslinked ultra high molecular weight polyethylene to ~~about~~ 80° C higher than the melting temperature.

45. (previously presented) A method for producing an ultra high molecular weight polyethylene block according to Claim 40, wherein said pressure is applied so as to deform the block.

46. (previously presented) A method for producing an ultra high molecular weight polyethylene block according to Claim 45, wherein said deformation is in a direction perpendicular to the plane of compression.

47. (previously presented) A method for producing an ultra high molecular weight polyethylene block according to Claim 46, wherein said block is cooled in a compression-deformed state under pressure.

48. (currently amended) A method for producing an ultra high molecular weight polyethylene block according to Claim 47, ~~which~~ wherein said block has an orientation of crystal planes in a direction parallel to the compression plane.

49. (currently amended) A method for producing an ultra high molecular weight polyethylene block according to Claim 46, wherein said block, after compression, has a thickness of at least ~~about~~ 5 mm in a direction perpendicular to the compression plane.

50. (currently amended) A method for producing an ultra high molecular weight polyethylene block according to Claim 46, wherein said block, prior to compression, has a thickness of at least ~~about~~ 3 cm.

51. (currently amended) A method for producing an ultra high molecular weight polyethylene block according to Claim 46, wherein said cooled block has a melting point of from ~~about~~ 135° C to ~~about~~ 155° C.

52. (previously presented) A method of producing an ultra high molecular weight polyethylene block according to Claim 40, wherein after said subjecting to pressure step, said block is subjected to isothermal crystallization.

53. (currently amended) A method for producing an ultra high molecular weight polyethylene block according to Claim 40, wherein after said subjecting to pressure step, said block is subjected to isothermal treatment at a temperature of from ~~about~~ around 100°C to ~~about~~ 130°C for a period of from ~~about~~ 1 hour to ~~about~~ 20 hours.

54. (currently amended) An artificial joint component for implantation in a human or other animal, wherein said component is formed from an ultra high molecular weight polyethylene block having a molecular weight not less than ~~about~~ 5 million, said block having been crosslinked by irradiation at a level of at least ~~about~~ 1 MR and after crosslinking having been heated, then subjected to pressure, and thereafter cooled.

55. (currently amended) An artificial joint component according to Claim 54, wherein said irradiation is gamma irradiation at a level of from ~~about~~ 1 MR to ~~about~~ 5 MR.

56. (currently amended) An artificial joint component according to Claim 54, wherein said heating is in a range of from ~~about~~ 50° C lower than the melting temperature of the crosslinked ultra high molecular weight polyethylene to ~~about~~ 80° C higher than the melting temperature.

57. (currently amended) An artificial joint component according to Claim 56, wherein said heating is in a range of from ~~about~~ 50° C lower than the melting temperature of the crosslinked ultra high molecular weight polyethylene to the melting temperature.

58. (currently amended) An artificial joint component according to Claim 56, wherein said heating is in a range from the melting temperature of the crosslinked ultra high molecular weight polyethylene to ~~about~~ 80° C higher than the melting temperature.

59. (previously presented) An artificial joint component according to Claim 54, wherein said pressure is applied so as to deform the block.

60. (previously presented) An artificial joint component according to Claim 59, wherein said deformation is in a direction perpendicular to the plane of compression.

61. (previously presented) An artificial joint component according to Claim 60, wherein said block is cooled in a compression-deformed state under pressure.

62. (previously presented) An artificial joint component according to Claim 61, which has an orientation of crystal planes in a direction parallel to the compression plane.

63. (currently amended) An artificial joint component according to Claim 60, wherein said block has a thickness, after compression, of at least ~~about~~ 5 mm in a direction perpendicular to the compression plane.

64. (currently amended) An artificial joint component according to Claim 60, wherein said block, prior to compression, has a thickness of at least ~~about~~ 3 cm.

65. (previously presented) An artificial joint component according to Claim 54, wherein said irradiation is conducted in the presence of oxygen.

66. (previously presented) An artificial joint component according to Claim 54, wherein said irradiation is conducted under a vacuum or in an inert atmosphere.

67. (previously presented) An artificial joint component according to Claim 54, wherein said block, after cooling, is processed to form said component.

68. (previously presented) An artificial joint component according to Claim 65, wherein said block, after cooling, is processed by a process comprising cutting said block to form said component.

69. (previously presented) An artificial joint component according to Claim 54, wherein said block has been subjected to isothermal crystallization.

70. (currently amended) An artificial joint component according to Claim 54, wherein said block has been subjected to isothermal treatment at a temperature of from ~~about~~ around 100°C to ~~about~~ 130°C for a period of from ~~about~~ 1 hour to ~~about~~ 20 hours.

71. (currently amended) An artificial joint component for implantation in a human or other animal, wherein said component is formed from an ultra high molecular weight polyethylene block having a molecular weight not less than ~~about~~ 5 million, said block having been crosslinked by irradiation at a level of at least ~~about~~ 1 MR and having then been heated to a temperature of from ~~about~~ 50° C lower than the melting temperature of the crosslinked ultra high molecular weight polyethylene to the melting temperature, then subjected to pressure, and thereafter cooled.

72. (currently amended) An artificial joint component according to Claim 71, wherein said irradiation is gamma irradiation at a level of from ~~about~~ 1 MR to ~~about~~ 5 MR.

73. (previously presented) An artificial joint component according to Claim 71, wherein said pressure is applied so as to deform the block.

74. (previously presented) An artificial joint component according to Claim 73, wherein said deformation is in a direction perpendicular to the plane of compression.

75. (previously presented) An artificial joint component according to Claim 74, wherein said block is cooled in a compression-deformed state under pressure.

76. (previously presented) An artificial joint component according to Claim 75, which has an orientation of crystal planes in a direction parallel to the compression plane.

77. (currently amended) An artificial joint component according to Claim 74, wherein said block has a thickness, after compression, of at least ~~about~~ 5 mm in a direction perpendicular to the compression plane.

78. (previously presented) An artificial joint component according to Claim 71, wherein said irradiation is conducted in the presence of oxygen.

79. (previously presented) An artificial joint component according to Claim 71, wherein said irradiation is conducted under a vacuum or in an inert atmosphere.

80. (previously presented) An artificial joint component according to Claim 71, wherein said block, after cooling, is processed to form said component.

81. (previously presented) An artificial joint component according to Claim 78, wherein said block, after cooling, is processed by a process comprising cutting said block to form said component.

82. (previously presented) An artificial joint component according to Claim 71, wherein said block has been subjected to isothermal crystallization.

83. (currently amended) An artificial joint component according to Claim 71, wherein said block has been subjected to isothermal treatment at a temperature of from ~~about~~ 100°C to ~~about~~ 130°C for a period of from ~~about~~ 1 hour to ~~about~~ 20 hours.

84. (currently amended) A method for producing an ultra high molecular weight polyethylene artificial joint component for implantation in a human or other animal, comprising:

- (a) crosslinking an ultra high molecular weight polyethylene block having a molecular weight not less than 5 million by irradiating the block with a high energy radiation at a level of at least ~~about~~ 1 MR;
- (b) heating said crosslinked block up to a compression deformable temperature;
- (c) subjecting said heated block to pressure; then
- (d) cooling said block; and
- (e) processing said cooled block to form said component.

85. (currently amended) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 84, wherein said irradiation is gamma irradiation at a level of from ~~about~~ 1 MR to ~~about~~ 5 MR.

86. (currently amended) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 84, wherein said heating is in a range of from ~~about~~ 50° C lower than the melting temperature of the crosslinked ultra high molecular weight polyethylene to ~~about~~ 80° C higher than the melting temperature.

87. (currently amended) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 86, wherein said heating is in a range of from ~~about~~ 50° C lower than the melting temperature of the crosslinked ultra high molecular weight polyethylene to the melting temperature.

88. (currently amended) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 86, wherein said heating is in a range from the melting temperature of the crosslinked ultra high molecular weight polyethylene to ~~about~~ 80° C higher than the melting temperature.

89. (previously presented) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 84, wherein said pressure is applied so as to deform the block.

90. (previously presented) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 89, wherein said deformation is in a direction perpendicular to the plane of compression.

91. (previously presented) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 90, wherein said block is cooled in a compression-deformed state under pressure.

92. (currently amended) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 91, ~~which~~ wherein said block has an orientation of crystal planes in a direction parallel to the compression plane.

93. (currently amended) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 90, wherein said block has a thickness, after compression, of at least ~~about~~ 5 mm in a direction perpendicular to the compression plane.

94. (currently amended) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 90, wherein said block, prior to compression, has a thickness of at least ~~about~~ 3 cm.

95. (currently amended) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 92, wherein said cooled block has a melting point of from ~~about~~ 135° C to ~~about~~ 155° C.

96. (previously presented) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 84, wherein said irradiation is conducted in the presence of oxygen.

97. (previously presented) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 84, wherein said irradiation is conducted under a vacuum or in an inert atmosphere.

98. (previously presented) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 84, additionally comprising processing said block, after cooling, to form said component.

99. (currently amended) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim ~~96~~84, additionally comprising processing said block, after cooling, by a process comprising cutting said block to form said component.

100. (previously presented) A method of producing an ultra high molecular weight polyethylene artificial joint component according to Claim 84, wherein after said subjecting to pressure step, said block is subjected to isothermal crystallization.

101. (currently amended) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 84, wherein after said subjecting to pressure step, said block is subjected to isothermal treatment at a temperature of from ~~about~~around 100°C to ~~about~~130°C for a period of from ~~about~~1 hour to ~~about~~20 hours.

102. (currently amended) An ultra high molecular weight polyethylene block having been crosslinked by irradiation, then subjected to pressure at a deformation temperature, and thereafter subjected to isothermal treatment.

103. (currently amended) An ultra high molecular weight polyethylene block according to Claim 102, wherein said irradiation is gamma irradiation at a level of at least ~~about~~ 1 MR.

104. (currently amended) An ultra high molecular weight polyethylene block according to Claim 102, wherein said deformation temperature is in a range of from ~~about~~ 50° C lower than the melting temperature of the crosslinked ultra high molecular weight polyethylene to ~~about~~ 80° C higher than the melting temperature.

105. (currently amended) An ultra high molecular weight polyethylene block according to Claim 104, wherein said deformation temperature is in a range of from ~~about~~ 50° C lower than the melting temperature of the crosslinked ultra high molecular weight polyethylene to the melting temperature.

106. (currently amended) An ultra high molecular weight polyethylene block according to Claim 104, wherein said deformation temperature is in a range from the melting temperature of the crosslinked ultra high molecular weight polyethylene to ~~about~~ 80° C higher than the melting temperature.

107. (previously presented) An ultra high molecular weight polyethylene block according to Claim 102, wherein said pressure is applied so as to deform the block.

108. (previously presented) An ultra high molecular weight polyethylene block according to Claim 107, wherein said block is cooled in a compression-deformed state under pressure.

109. (previously presented) An ultra high molecular weight polyethylene block according to Claim 108, which has an orientation of crystal planes in a direction parallel to the compression plane.

110. (currently amended) An ultra high molecular weight polyethylene block according to Claim 102, wherein said isothermal treatment is at a temperature of from ~~about~~ around 100° C to ~~about~~ 130° C for a period of from ~~about~~ 1 hour to ~~about~~ 20 hours.

111. (currently amended) A method for producing an ultra high molecular weight polyethylene block, comprising:

- (a) crosslinking an ultra high molecular weight polyethylene block having a molecular weight not less than 5 million by irradiating the block with a high energy radiation at a level of at least ~~about~~ 1 MR;
- (b) subjecting said crosslinked block to pressure at a deformation temperature; and thereafter
- (c) subjecting said block to isothermal treatment.

112. (currently amended) A method for producing an ultra high molecular weight polyethylene block according to Claim 111, wherein said irradiation is gamma irradiation at a level of at least ~~about~~ 1 MR.

113. (currently amended) A method for producing an ultra high molecular weight polyethylene block to Claim 111, wherein said deformation temperature is in a range of from ~~about~~ 50° C lower than the melting temperature of the crosslinked ultra high molecular weight polyethylene to ~~about~~ 80° C higher than the melting temperature.

114. (currently amended) A method for producing an ultra high molecular weight polyethylene block according to Claim 113, wherein said deformation temperature is in a range of from ~~about~~ 50° C lower than the melting temperature of the crosslinked ultra high molecular weight polyethylene to the melting temperature.

115. (currently amended) A method for producing an ultra high molecular weight polyethylene block according to Claim 113, wherein said deformation temperature is in a range from the melting temperature of the crosslinked ultra high molecular weight polyethylene to ~~about~~ 80° C higher than the melting temperature.

116. (previously presented) A method for producing an ultra high molecular weight polyethylene block according to Claim 111, wherein said pressure is applied so as to deform the block.

117. (previously presented) A method for producing an ultra high molecular weight polyethylene block according to Claim 116, wherein said block is cooled in a compression-deformed state under pressure.

118. (currently amended) A method for producing an ultra high molecular weight polyethylene block according to Claim 111, wherein said isothermal treatment is at a temperature of from ~~about~~around 100° C to ~~about~~ 130° C for a period of from ~~about~~ 1 hour to ~~about~~ 20 hours.

119. (currently amended) An artificial joint component for implantation in a human or other animal, wherein said component is formed from an ultra high molecular weight polyethylene block having been crosslinked by irradiation, then subjected to pressure at a deformation temperature, and then subjected to isothermal treatment.

120. (currently amended) An artificial joint component according to Claim 119, wherein said irradiation is gamma irradiation at a level of at least ~~about~~about 1 MR.

121. (currently amended) An artificial joint component according to Claim 119, wherein said deformation temperature is in a range of from ~~about~~ 50° C lower than the melting temperature of the crosslinked ultra high molecular weight polyethylene to ~~about~~ 80° C higher than the melting temperature.

122. (currently amended) An artificial joint component according to Claim 121, wherein said deformation temperature is in a range of from ~~about~~ 50° C lower than the melting temperature of the crosslinked ultra high molecular weight polyethylene to the melting temperature.

123. (currently amended) An artificial joint component according to Claim 121, wherein said deformation temperature is in a range from the melting temperature of the crosslinked ultra high molecular weight polyethylene to ~~about~~ 80° C higher than the melting temperature.

124. (previously presented) An artificial joint component according to Claim 119, wherein said pressure is applied so as to deform the block.

125. (previously presented) An artificial joint component according to Claim 124, wherein said block is cooled in a compression-deformed state under pressure.

126. (previously presented) An artificial joint component according to Claim 119, wherein said irradiation is conducted in the presence of oxygen.

127. (previously presented) An artificial joint component according to Claim 126, wherein, after said isothermal treatment, said block is processed by a process comprising cutting said block to form said component.

128. (currently amended) A method for producing an ultra high molecular weight polyethylene artificial joint component for implantation in a human or other animal, comprising:

- (a) crosslinking an ultra high molecular weight polyethylene block by irradiating the block with a high energy radiation;
- (b) subjecting said ~~heated~~irradiated block to pressure at a deformation temperature; ~~and then~~
- (c) subjecting said block to isothermal treatment; and thereafter
- (d) processing said block to form said component.

129. (currently amended) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 128, wherein said irradiation is gamma irradiation at a level of at least ~~about~~ 1 MR.

130. (currently amended) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 128, wherein said deformation temperature is in a range of from ~~about~~ 50° C lower than the melting temperature of the crosslinked ultra high molecular weight polyethylene to ~~about~~ 80° C higher than the melting temperature.

131. (currently amended) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 130, wherein said deformation temperature is in a range of from ~~about~~ 50° C lower than the melting temperature of the crosslinked ultra high molecular weight polyethylene to the melting temperature.

132. (currently amended) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 130, wherein said deformation temperature is in a range from the melting temperature of the crosslinked ultra high molecular weight polyethylene to ~~about~~ 80° C higher than the melting temperature.

133. (previously presented) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 128, wherein said pressure is applied so as to deform the block.

134. (previously presented) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 128, wherein said irradiation is conducted in the presence of oxygen.

135. (previously presented) A method for producing an ultra high molecular weight polyethylene artificial joint component according to Claim 134, wherein said processing step comprises cutting said block to form said component.

136. (currently amended) A method for producing an ultra high molecular weight polyethylene block according to Claim 128, wherein said isothermal treatment is at a temperature of from ~~about~~ around 100° C to ~~about~~ 130° C for a period of from ~~about~~ 1 hour to ~~about~~ 20 hours.